## PATENT COOPERATION TREATY

Mail Stop PCT, Attn: IPEA/US Commissioner for Patents P.O. Box 1450 Alexandria, Virginia 22313-1450 Facsimile No. (571) 273-3201  Authbrized officer  Mare Jimenez Telephone No. (571) 272-4530	L PRELIMINARY EXAMINING AUTHORITY					
Applicant's or agent's file reference  Applicant's or agent's file reference  BEPLY DUE  Mithin 1 months/days from the above date of mailing  (day/month/year)  Applicant's or agent's file reference  BEPLY DUE  Mithin 1 months/days from the above date of mailing  (day/month/year)  Of January 2005 (04.01.2005)  PCT/US05/00095  Of January 2005 (04.01.2005)  Of January 2005 (04.01.2005)  International application (IPC) or both national classification and IPC  ISPC: 29/880.045, 780.049, 727/370.02, 370.13, 370.13, 370.16, 370.17, 370.18, 370.21  Applicant  COOPER-STANDARD AUTOMOTIVE INC.  1.	. H. BUTCHKO	PCT				
Applicant's or agent's file reference  Applicant's or agent's file reference  BEPLY DUE  Mithin 1 months/days from the above date of mailing  (day/month/year)  Applicant's or agent's file reference  BEPLY DUE  Mithin 1 months/days from the above date of mailing  (day/month/year)  Of January 2005 (04.01.2005)  PCT/US05/00095  Of January 2005 (04.01.2005)  Of January 2005 (04.01.2005)  International application (IPC) or both national classification and IPC  ISPC: 29/880.045, 780.049, 727/370.02, 370.13, 370.13, 370.16, 370.17, 370.18, 370.21  Applicant  COOPER-STANDARD AUTOMOTIVE INC.  1.	400 WEST MAPLE ROAD, SUITE 37	WRITTEN OPINION OF THE				
Applicant's or agent's file reference  60158-286  International application No.  PCTUSOS/00095  Ot January 2005 (04 January 2	BIRMINGHAM, MI 48009	INTERNATIONAL PRELIMINARY				
Date of mailing   dos/month/year   3 1 MAY 2006	/ 9					
Applicant's or agent's file reference 60158-286  International application No. International filing date (day/month/spar) Priority date (day/month/spar) Pr	JUN U 2 2006	<u>/</u>				
within 1 months/days from the above date of mailling for the following date of the above date of mailling date date of the above date of mailling above date of m	PECHVED!	(day/month/year) 3 1 MAY 2006				
the above date of mailing  International application No.  Ot January 2005 (04.01.2005)  Ot January 2005 (04.01.2005)  Ot January 2005 (04.01.2005)  Ot January 2004 (01.05.2004)  International Patent Classification (IPC) or both national classification and IPC  IPC. B110 \$306(2006.01), B21C 37/20(2006.01)  USPC: 29/890.045,890.049;72/370.02,370.1,370.13,370.16,370.17,370.18,370.21  Applicant  COOPER.STANDARD AUTOMOTIVE INC.  I. The written opinion established by the International Searching Authority.  is is not considered to be a written opinion of the International Preliminary Examining Authority.  2. This second (first, etc.) opinion contains indications relating to the following items:  Box No. I. Basis of the opinion  Box No. III Priority  Box No. III Non-establishment of opinion with regard to novelty, inventive step and industrial applicability Box No. IV Lack of unity of invention  Box No. IV Reasoned statement under Rule 66.2 (a)(ii) with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement  Box No. VI Certain defects in the international application  Box No. VII Certain defects in the international application  Box No. VIII Certain observations on the international application  3. The applicant is hereby invited to reply to this opinion.  When? See the time limit indicated above. The applicant may, before the expiration of that time limit, request this Authority to grant an extension, see Rule 66.4.  How? By submitting a written reply, accompanied, where appropriate, by amendments, according to Rule 66.3.  For the examiner's obligation to consider amendments, ace Rule 66.4.  If no reply is filed, the international preliminary report on patentability (Chapter II of the PCT) must be established according to Rule 69.2 is: 91. September 2006 (91.99 2096)  Name and mailing address of the IPEA/US Alexandra, Virginia 22313-1450  Port Box 1409  Alexandra, Virginia 22313-1450	Applicant's or agent's file reference					
International application No. International filing date (day/month/year) Priority date (day/month/year) O4 January 2005 (04.01.2005) O1 May 2004 (01.05.2004) O1 May 2004 (	60158-286	the above date of mailing				
International Patent Classification (IPC) or both national classification and IPC  IPC: B21D 53/06(2006.01),B21C 37/20(2006.01)  USPC: 29/8000-045,900-045,97/20/37/0.02,37/0.1,37/0.13,370.16,370.17,370.18,370.21  Applicant  COOPER-STANDARD AUTOMOTIVE INC.  1. The written opinion established by the International Searching Authority:  is is not considered to be a written opinion of the International Preliminary Examining Authority.  2. This second (first, etc.) opinion contains indications relating to the following items:  Box No. I Basis of the opinion  Box No. II Priority  Box No. II Non-establishment of opinion with regard to novelty, inventive step and industrial applicability  Box No. IV Lack of unity of invention  Box No. V Reasoned statement under Rule 66.2 (a)(ii) with regard to novelty, inventive step or industrial applicability; citations and explanations supporting such statement  Box No. VII Certain defects in the international application  Box No. VIII Certain defects in the international application  Box No. VIII Certain defects in the international application  3. The applicant is hereby lavited to reply to this opinion.  When? See the time limit indicated above. The applicant may, before the expiration of that time limit, request-this Authority-to-grant an extension, see Rule 66.2(e).  How? By submitting a written reply, accompanied, where appropriate, by amendments, according to Rule 66.3. For an additional opportunity to submit amendments, see Rule 66.6. For an additional opportunity to submit amendments, see Rule 66.6. For an additional opportunity to submit amendments, see Rule 66.6. For an additional opportunity to submit amendments, see Rule 66.6. For an additional opportunity to submit amendments, see Rule 66.6. For an additional opportunity to submit amendments, see Rule 66.6. For an additional opportunity to submit amendments, see Rule 66.6. For an additional opportunity to submit amendments, see Rule 66.6. For an additional opportunity to submit amendments, see Rule 66.6. For an addition	International application No. International filing date					
International Patent Classification (IPC) or both national classification and IPC  IPC: B21D 53/06 2006.01);B21C 37/20 (2006.01)  USPC: 29/890.045,890.049;72/370.02,370.1,370.13,370.16,370.17,370.18,370.21  Applicant  COOPER-STANDARD AUTOMOTIVE INC.  1. The written opinion established by the International Searching Authority:	PCT/US05/00095   04 January 2005 (04.01.2)	2005)				
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Box No. IV						
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P.O. Box 1450 Alexandria, Virginia 22313-1450 Facsimile No. (571) 273-3201  Telephone No. (571) 272-4530	Complete Co., Aut. u EAVOS					
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## WRITTEN OPINION OF THE INTERNATIONAL PRELIMINARY EXAMINING AUTHORITY

International application No.	
PCT/US05/00095	

В	x No.	. I	Basis of the opinion				
1.	With	reg	gard to the language, this opinion has been established on the basis of:				
	$\square$		e international application in the language in which it was filed.				
		a translation of the international application into English, which is the language of a translation furnished for the purposes of:  international search (under Rules 12.3 and 23.1(b))					
			publication of the international application (under Rule 12.4(a))				
			international preliminary examination (under Rules 55.2(a) and/or 55.3(a))				
2.	which	h ha	ard to the elements of the international application, this opinion has been established on the basis of (replacement sheets two been furnished to the receiving Office in response to an invitation under Article 14 are referred to in this opinion as lly filed."):				
		the	e international application as originally filed/furnished				
	$\boxtimes$		e description:				
		pa	ges 1-5 as originally filed/furnished				
		_	ges NONE received by this Authority on				
	_	pa	ges NONE received by this Authority on				
	$\bowtie$		e claims:				
		_	ges NONE as originally filed/furnished				
		_	ges NONE as amended (together with any statement) under Article 19 ges 6 and 7 received by this Authority on 30 August 2005 (30.08.2005)				
		_	ges 6 and 7 received by this Authority on 30 August 2005 (30.08.2005) ges NONE received by this Authority on				
		-	<u> </u>				
	$\boxtimes$		e drawings:				
		_	ges 1/4-4/4 as originally filed/furnished				
-		-	ges NONE received by this Authority on received by the recei				
		-					
	Ш	a s	sequence listing and/or any related table(s) - see Supplemental Box Relating to Sequence Listing.				
3.	$\boxtimes$	Th	ne amendments have resulted in the cancellation of:				
			the description, pages				
		$\triangleright$	the claims, Nos. 18 and 19				
		Ē	the drawings, sheets/figs				
		F	the sequence listing (specify):				
		F	any table(s) related to the sequence listing (specify):				
4.		Th	nis opinion has been established as if (some of) the amendments had not been made, since they have been considered to go yound the disclosure as filed, as indicated in the Supplemental Box (Rule 70.2(c)).				
			the description, pages				
			the claims, Nos.				
		Ī	the drawings, sheets/figs				
		F	the sequence listing (specify):				
		F	any table(s) related to the sequence listing (specify):				
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## WRITTEN OPINION OF THE INTERNATIONAL PRELIMINARY EXAMINING AUTHORITY

International application No. PCT/US05/00095

Box No. V Reasoned statement under R applicability; citations and ex	tule 66.2(a)(ii) with regard to novelty, planations supporting such statement	, inventive step or industrial				
1. Statement						
Novelty (N)	Claims 17	YES				
,	Claims 1-16	1				
		<b>VICO</b>				
Inventive Step (IS)	Claims NONE	_ [				
	Claims 1-17	110				
Industrial Applicability (IA)	Claims 1-17	YES				
	Claims NONE	NO				
2. Citations and Explanations: Claims 1-3, 5, 7 and 9-14 lack novelty under PCT Article 33(2) as being anticipated by Takashi et al. (US4715436). Takashi et al. teach in figure 1a: positioning a circular tube (1) in a first position, forming an indentation (3) on the tube with a mold/roller (2), moving the tube to a second position (see arrows showing rotation of the tube) relative to the mold (2), and releasing (see arrows pointing to left) the mold from the tube (2). Note that indentation is repeated by (2). Rotational moving occurs before releasing the tube (2). As shown in figure 1a, rotating occurs approximately 5 to 10 degrees between each step of repeating. Note the plurality of rollers (2).  Claims 1-8 and 10-16 lack novelty under PCT Article 33(2) as being anticipated by Beutler et al. (US6488078). Beutler et al. teach positioning a circular tube (1) in a first position, forming an indentation (7) on the tube with a mold/roller (10), moving the tube to a second position (see arrows showing rotation of the tube) relative to the mold (2), and releasing the mold from the tube (2). Note that indentation is repeated by (10). Rotational moving occurs before releasing the tube (10). As shown in figure 8, rotating occurs approximately 5 to 10 degrees between each step of repeating. Note the plurality of rollers (col. 4, line 11). Note in figure 11 there is a secondary former (16) which meets the step of moving occurring after a releasing step. The releasing step from the first former (13).  Claim 17 lacks an inventive step under PCT Article 33(3) as being obvious over Beutler et al. Beutler et al. do not specifically disclose a valve to control a flow of the first fluid into the tubes and parallel indentations. However, official notice is taken that it was well known to a person of ordinary skill in the art, at the time of the invention, to have provided a control valve to control fluid flow and to include parallel indentations depending upon the desired has a functional provided to the relative to the relativ						

## WRITTEN OPINION OF THE INTERNATIONAL PRELIMINARY EXAMINING AUTHORITY

International application No. PCT/US05/00095

Supplemental Box (To be used when the space in	n any of the preceding boxes	s is not sufficient.)						
TIME LIMIT: The time limit set for response to a Written Opinion may not be extended. 37 CFR 1.484(d). Any response received after the expiration of the time limit set in the Written Opinion will not be considered in preparing the International Preliminary Report on Patentability (Chapter II of the Patent Cooperation Treaty).								
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